



Dart Aerospace Ltd.
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RBH5610-705-40101-PO
Job Sheet 182938



Part No: RBH5610-705-40101-PO **Job Qty:** 1 ea

Part Name: Inspection Fixture Fan Assembly Trans & Coupling



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/6/18

Job Tracking No:

Due Date: 11/5/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBH5610-705-40101 Rev. 3 IPP Rev. A 18.08.28 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	1 pcs		11/5/18	0.00	0.00	Purchasing		NOV 14 2018
110	Packaging	1 pcs		11/5/18	0.00	0.00	Packaging2		NOV 14 2018
120	QC	1 pcs		11/5/18	0.00	0.00	QC6		NOV 14 2018
130	Small Fab	1 pcs		11/5/18	0.00	0.20	Small Fab-6		NOV 15 2018
140	QC	1 pcs		11/5/18	0.00	0.00	QC5		NOV 15 2018
145	DC	1 pcs		11/5/18	0.00	0.00	DC		NOV 15 2018
150	Packaging	1 pcs		11/5/18	0.00	0.00	Packaging3		NOV 15 2018
160	QC21-FG	1 Ea		11/5/18	0.00	0.00	QC21		NOV 15 2018

Part Op 100 - Issue PO to METEC P/O: 040950 MANUFACTURE RBH5610-705-40101 AS PER DWG - Certificate of Descriptions: conformity is required

130 - Pack case

145 - Print and cut out RBH5610-705-40101-27 instruction card and put in case ***NOTE*** User red paper as per DWG. Found in FS1/Eugene Reference/Supplier Cad Data.

SEPT 06. 2018 x 1 RH

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBH5610-705-40101P	Inspection Fixture Fan Assembly Trans & Coupling	1 Ea (1 ea)	100-Purchasing	5127918
10164	LG. Pistol Case, Plastic	1 Ea (1 ea)	130-Small Fab	5096400

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBH5610-705-40101P	1	0	0
130-Small Fab	10164	1	2	0

Part Specifications

Specifications could not be found.

Plex 9/6/18 2:40 PM dart.Lussier.Patrick



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Container No: **S127920**



Inspection Fixture Fan Assembly Trans & Coupling

PART NO: **RBH5610-705-40101**

Serial No/Batch: **S127920**

Revision: **P0**

Operation: **Purchasing**

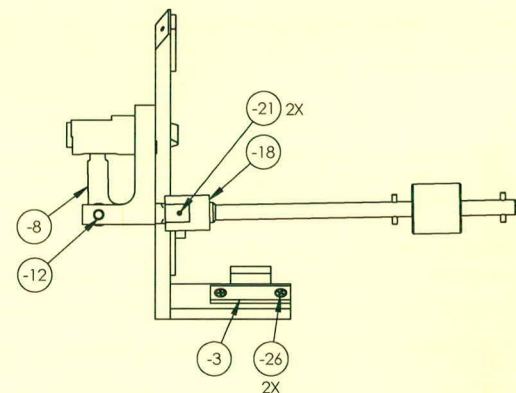
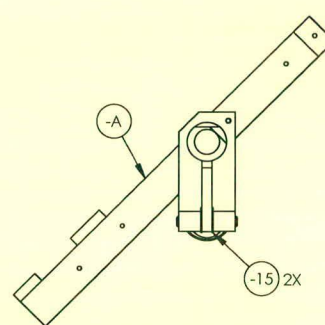
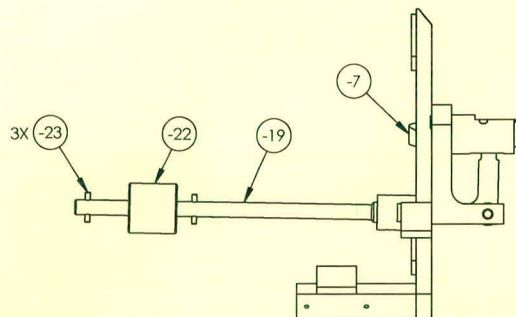
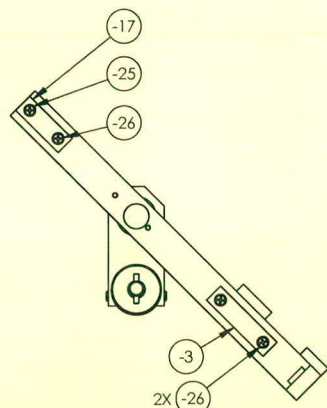
Change No:

Mfg Date: 11/14/18

Job No: 182938

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REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	
2	15-0289	ADDED VIEW ON SHT 1 TO CLARIFY PART LOCATIONS. -A ADDED DIMS .50, (1.5), 2.0 TO LOCATE -2, CHD WELD CALLOUT WAS 1/16 X 50% 2 PLACES 180° APART IS 1/16 X 50% 2 PLACES. ADDED FILLET WELD A1-1 & -4. ADDED MISSING 2X -24, -1, -2, -4, -5, -22 CHD MATERIAL WAS 1018 IS 1018/1020. -3, -17 CHD DIM WAS 2X Ø.136 THRU ALL √ Ø.252 X 82° IS 2X Ø.136 THRU ALL √ Ø.30 X 82°. ADDED DIM 2X .250, -8 CHD DIM WAS .600 IS .63. -19 CHD DIM WAS 2X Ø.1249, .1244 IS 3X Ø.1249, .1244. DELETED DIM 7.12. CHD DIM WAS (2.68) IS 2.68. WAS .45 IS .59. ADDED DIMS 2X .03 X 45°, .06 X 45°, .32.	9/3/2015	RJC	JAG	
3	16-0067	-A DELETED 2.58 DIM. CHD WELD CALLOUT WAS FILLET WELD 1/16 X 50 2 PLACES IS FILLET WELD 1/16 X 7/8. -1, -2, -4, -5 & -22 CHD MATERIAL WAS 1018/1020 IS A36/1018/1020. -4 ADDED ENGRAVE NOTE. ADDED DIM 7X .438. CHD DIM WAS Ø1.000 √ .03 IS Ø.9828 - .9816 √ .03 S.F. -5, -8 CHD DIM WAS Ø1.000 IS .9800 - .9792 S.F. -4 & -6. ADDED S.F. -7 TO Ø.6272 - .6262 DIM. -4 CHD DIM WAS 2X .50 IS 2X (.50). ADDED LEADER TO 2ND FACE TO SKIM CUT. CHD DIM WAS Ø1.0012 - 1.0000 IS Ø.9828 - .9816 S.F. -5, -7 ADDED S.F. TO DIM Ø.625 - .624. -18 CHD DIMS WAS Ø.503-.501 THRU IS Ø.503-.501 √ .500. WAS .253-.251 √ .60 IS .253-.251 THRU ALL. ADDED S.F. -19 TO Ø.503-.501 √ .500 DIM. -19 ADDED S.F. -18 TO Ø.500 - .499 DIM. ADDED S.F. -22 TO Ø.3740 - .3734 DIM. ADDED P.F. TO 3X Ø.1249 - .1244 DIM. -22 ADDED S.F. -19 TO Ø.3759 - .3750 DIM.	7/5/2016	RJC	JAG	

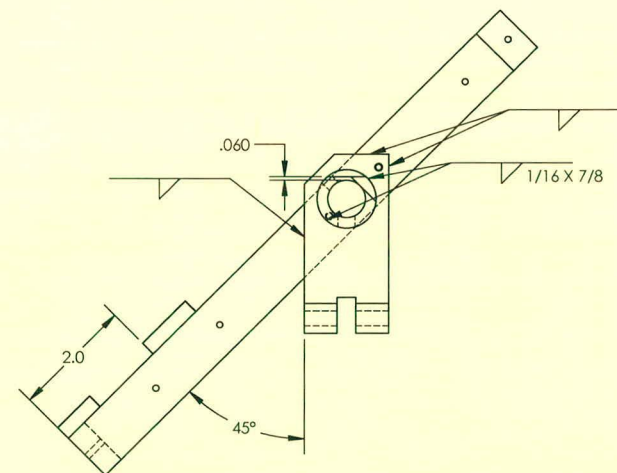
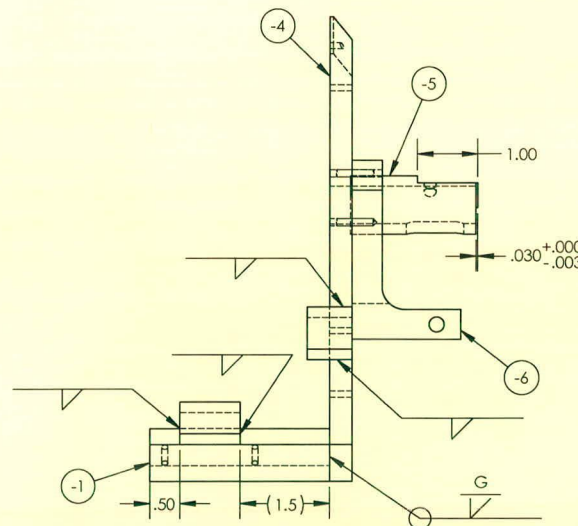
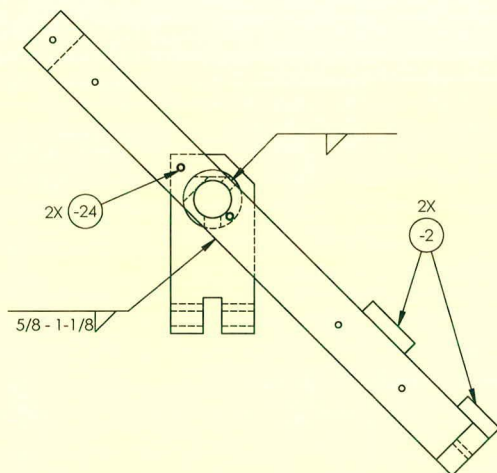
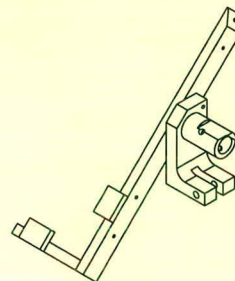


ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-A	1	WELDMENT			2
	1		-1	1	LEG	A36/1018/1020 HR		3
	2		-2	2	PAD	A36/1018/1020 HR		4
			-3	2	PLATE	01		5
	1		-4	1	BAR	A36/1018/1020 HR		6
	1		-5	1	SLEEVE	A36/1018/1020 HR		7
	1		-6	1	LEG	HR ANGLE		8
			-7	1	PIN	01		9
			-8	1	LEVER	01		10
	B/O		-12	1	DOWEL PIN	STEEL	Ø1/4 X 1-1/2 (MCMaster-CARR #98381A546)	1
	B/O		-15	2	FLAT WASHER	BRASS	Ø1/4 I.D. X 9/16 O.D. (MCMaster-CARR #92916A365)	1
			-17	1	SMALL PLATE	01		11
			-18	1	SMALL SLEEVE	6061		12
			-19	1	LONG PIN	6061		13
	B/O		-21	2	BALL SPRING PLUNGER	STEEL	5-40 X 1/4 (MCMaster-CARR #3408A66)	1
			-22	1	WEIGHT	A36/1018/1020 HR		14
	B/O		-23	3	DOWEL PIN	STEEL	Ø1/8 X 3/4 (MCMaster-CARR #98381A473)	1
	2		-24	2	DOWEL PIN	STEEL	Ø1/8 X 5/8 (MCMaster-CARR #98381A472)	2
	B/O		-25	1	FLAT HEAD MACHINE SCREW	STEEL	5-40 x 1/4 (MSC #40914814)	1
	B/O		-26	5	FLAT HEAD MACHINE SCREW	STEEL	5-40 X 3/8 (MSC #09173329)	1
			-27	1	INSTRUCTION SHEET	RED CONSTRUCTION PAPER	4 X 4	15
	B/O		-28	1	CASE	PLASTIC	4 GUN PELICAN #10164	N/S
	ASSY -A							

DART AEROSPACE	
TITLE INSPECTION FIXTURE FAN ASSY. TRANS. & COUPLING	
DWG NO. RBH5610-705-40101	REV 3
MAT'L PART FINISH SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES ± 125	
1. BREAK ALL SHARP EDGES .015 X 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: CLOUGH CHECKED: DUERFELDT OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
USED ON MODEL MD500	
SCALE 1:3	DATE 6/11/2012
SHEET 1 OF 15	

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REVISIONS			DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION			
2	15-0289	ADDED DIMS .50, (1.5), 2.0 TO LOCATE -2. CHD WELD CALLOUT WAS 1/16 X 50% 2 PLACES 180° APART IS 1/16 X 50% 2 PLACES, ADDED FILLET WELD AT -1 & -4. ADDED MISSING 2X -24.	9/3/2015	RJC	JAG
3	16-0067	DELETED 2.58 DIM, CHD WELD CALLOUT WAS FILLET WELD 1/16 X 50 2 PLACES IS FILLET WELD 1/16 X 7/8.	7/5/2016	RJC	JAG

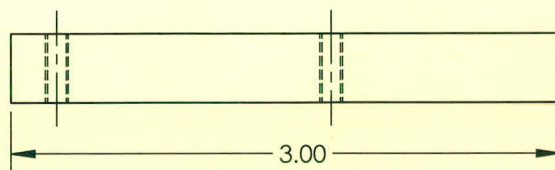
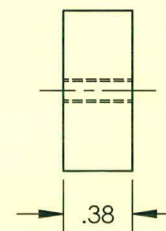
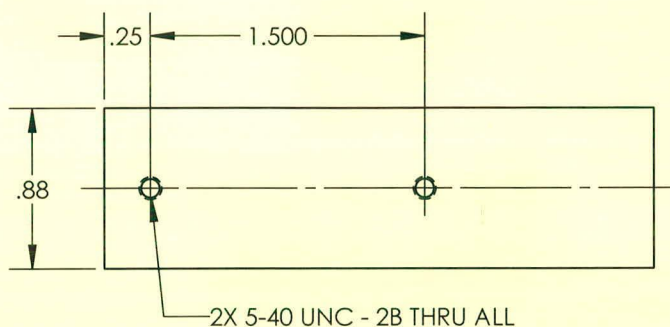
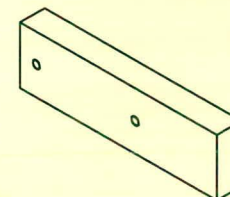


(A)
WELDMENT

DART AEROSPACE	
TITLE INSPECTION FIXTURE FAN ASSY. TRANS. & COUPLING	
DWG NO. RBH5610-705-40101-A	REV 3
MAT'L _____ HEAT TREAT _____ FINISH BLACK OXIDE SPEC QMSI 6.2.2 REV D DRAWN BY: CLOUGH CHECKED: DUERFELDT OPFS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES ± 125 1. BREAK ALL SHARP EDGES .015 ± .45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.3M-2009 USED ON MODEL MD500	
SCALE 1:2	DATE 6/11/2012 SHEET 2 OF 15

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0289	-1 CH'D MATERIAL WAS 1018 IS 1018/1020.	9/3/2015	RJC	JAG
3	16-0067	-1 CH'D MATERIAL WAS 1018/1020 IS A36/1018/1020.	7/5/2016	RJC	JAG

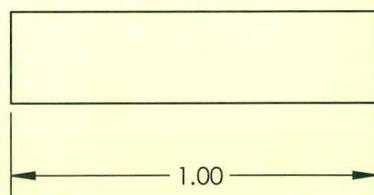
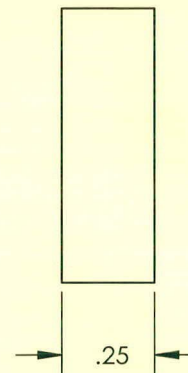
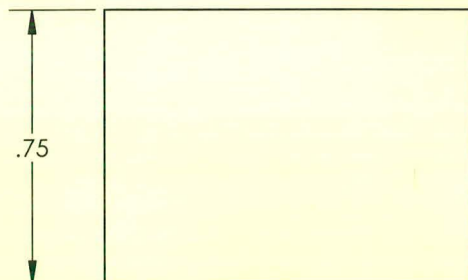
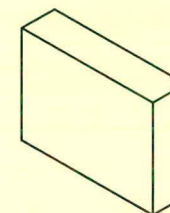


(-1)
LEG

DART AEROSPACE	
TITLE INSPECTION FIXTURE FAN ASSY. TRANS & COUPLING	
DWG NO. RBH5610-705-40101-1	REV 3
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT RC 56-60	.XXX ± .005 FRACTIONS ± 1/8
TREAT	.XX ± .01 ANGLES ± 5°
FINISH SEE -A WELDMENT	.X ± .1 SURFACES = 125/√
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DUERFELDT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	MD500
APPROVED: GILBERT	
SCALE 1:1	DATE 6/11/2012 SHEET 3 OF 15

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0289	-2 CH'D MATERIAL WAS 1018 IS 1018/1020.	9/3/2015	RJC	JAG
3	16-0067	-2 CH'D MATERIAL WAS 1018/1020 IS A36/1018/1020.	7/5/2016	RJC	JAG

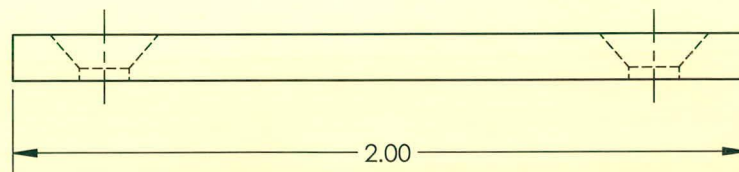
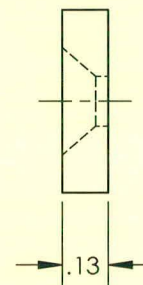
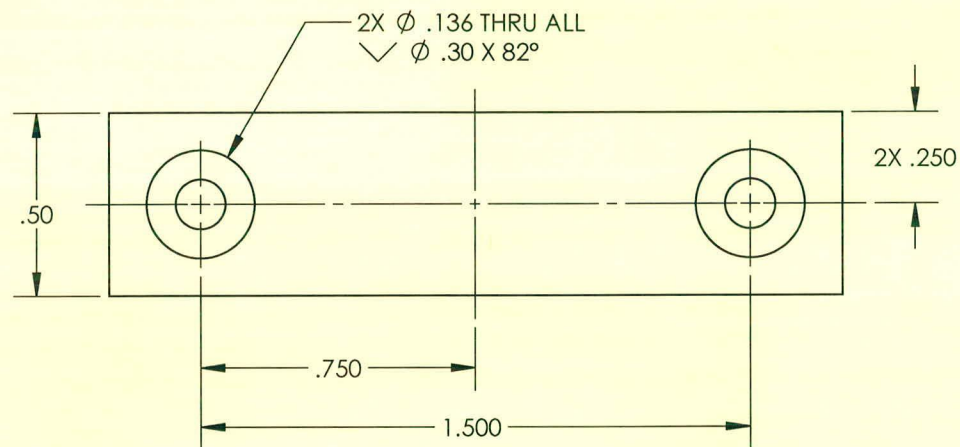


②
PAD

DART AEROSPACE	
TITLE INSPECTION FIXTURE FAN ASSY. TRANS. & COUPLING	
DWG NO. RBH5610-705-40101-2	REV 3
MATL A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT SEE -A WELDMENT	.XXX ± .005 FRACTIONS ± 1/8
FINISH SEE -A WELDMENT	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125/✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	MD 500
SCALE 2:1	DATE 6/11/2012 SHEET 4 OF 15

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REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED
2	15-0289	-3 CH'D DIM WAS 2X Ø.136 THRU ALL ✓ Ø.252 X 82° IS 2X Ø.136 THRU ALL ✓ Ø.30 X 82°, ADDED DIM 2X .250.			9/3/2015	RJC	JAG



(-3)

PLATE



TITLE INSPECTION FIXTURE FAN ASSY.
TRANS & COUPLING

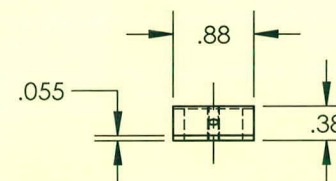
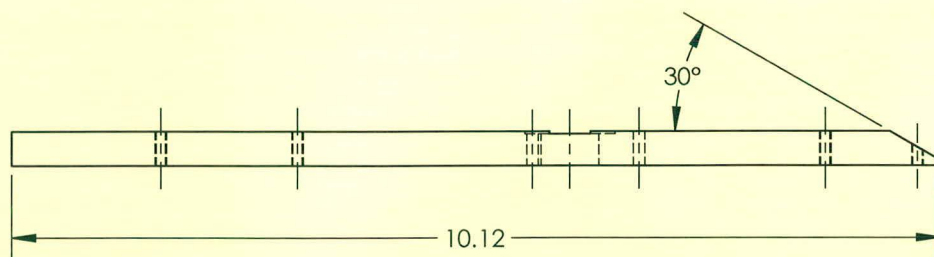
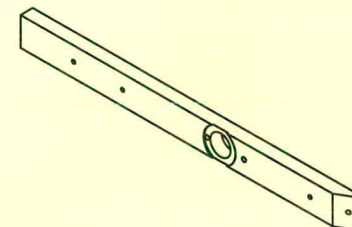
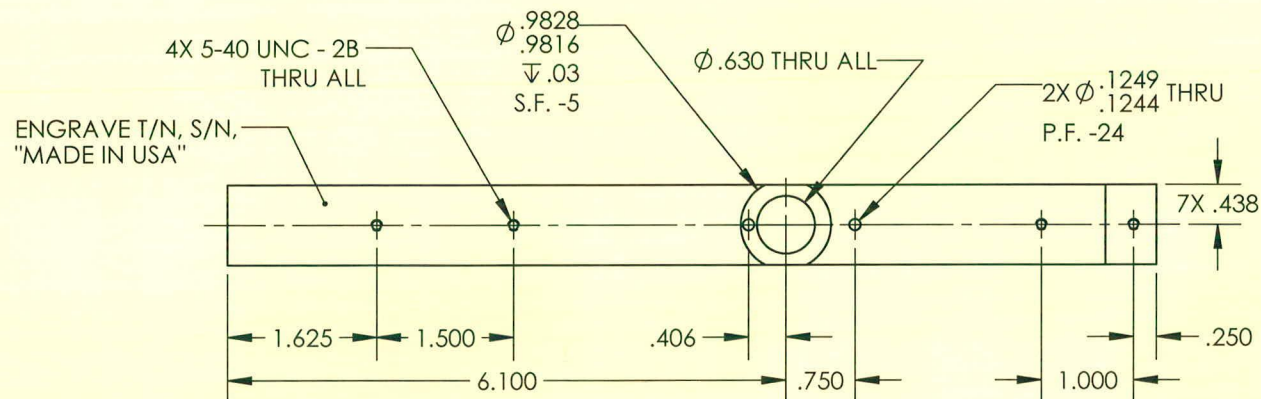
DWG NO. RBH5610-705-40101-3

REV 3

MATERIAL 01		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT	RC 56-60	DIMENSIONS ARE IN INCHES	
FINISH	BLACK OXIDE	.XXX ± .005	FRACTIONS ± 1/8
SPEC	QMSI-6.2.2 REV D	.XX ± .01	ANGLES ± 5°
DRAWN BY:	CLOUGH	.X ± .1	SURFACES = 125 ✓
CHECKED:	DUERFELDT	1. BREAK ALL SHARP EDGES	
OPPS APPR:	ANDERSON	.015 x 45° OR .015R	
QA APPR:	LINDSAY	2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
APPROVED:	GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
SCALE	2:1	DATE	6/11/2012
		USED ON MODEL MD500	
		SHEET 5 OF 15	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0289	-4 CH'D MATERIAL WAS 1018 IS 1018/1020.	9/3/2015	RJC	JAG
3	16-0067	-4 CH'D MATERIAL WAS 1018/1020 IS A36/1018/1020, ADDED ENGRAVE NOTE, ADDED DIM 7X .438, CH'D DIM WAS $\varnothing 1.000 \pm .03$ IS $\varnothing .9828 - .9816 \pm .03$ S.F. -.5.	7/5/2016	RJC	JAG



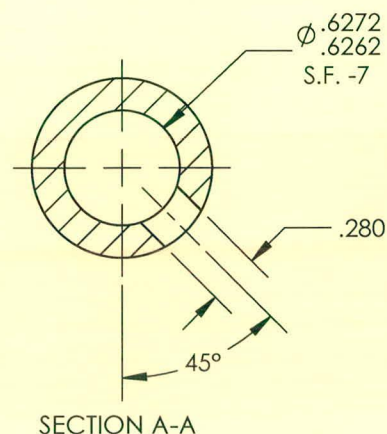
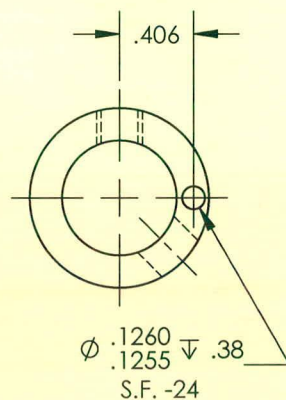
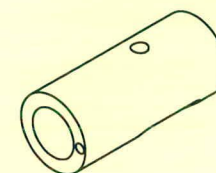
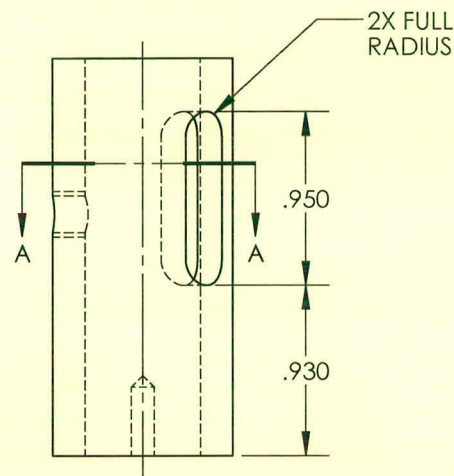
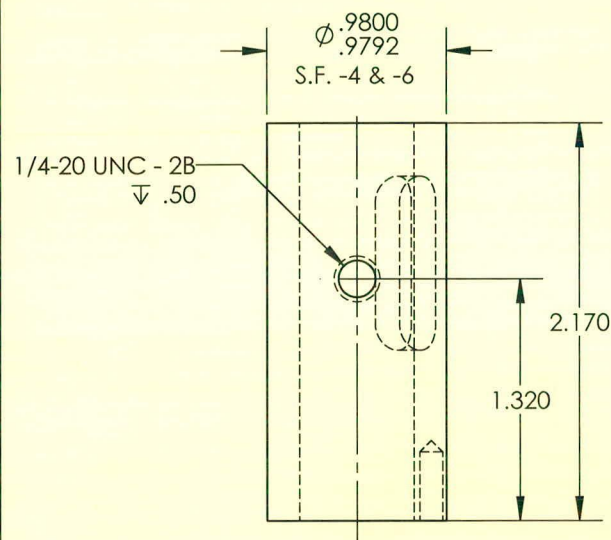
(-4)

BAR

DART AEROSPACE	
TITLE INSPECTION FIXTURE FAN ASSY. TRANS & COUPLING	
DWG NO. RBH5610-705-40101-4	REV 3
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT SEE -A WELDMENT	.XXX $\pm .005$ FRACTIONS $\pm 1/8$
FINISH SEE -A WELDMENT	.XX $\pm .01$ ANGLES $\pm 5^\circ$
SPEC	.X $\pm .1$ SURFACES = 125 ✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	MD500
SCALE 1:2	DATE 6/11/2012
SHEET 6 OF 15	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0289	-5 CH'D MATERIAL WAS 1018 IS 1018/1020.	9/3/2015	RJC	JAG
3	16-0067	-5 CH'D MATERIAL WAS 1018/1020 IS A36/1018/1020, CH'D DIM WAS (Ø1.000) IS .9800 - .9792 S.F. -4 & -6, ADDED S.F. -7 TO Ø.6272 - .6262 DIM.	7/5/2016	RJC	JAG

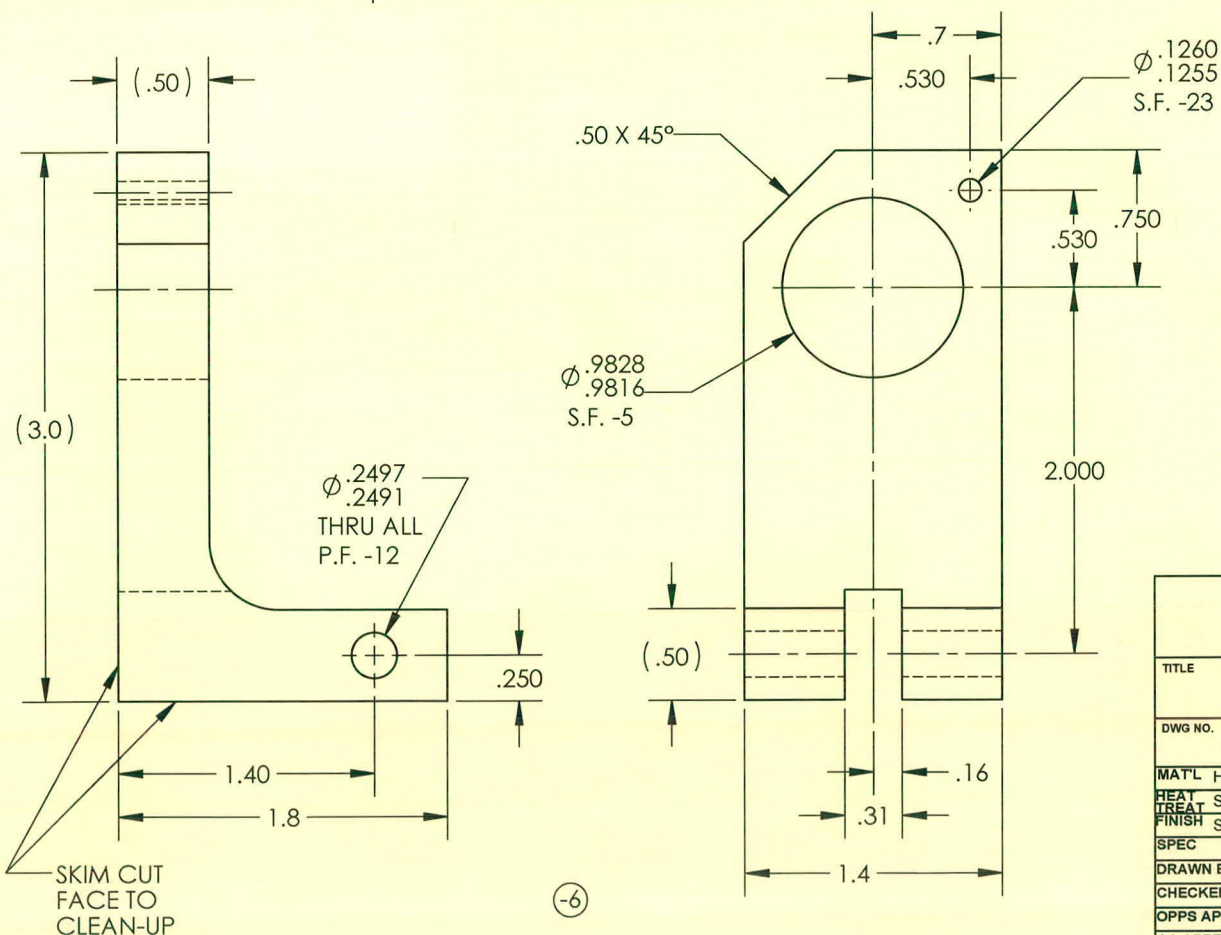
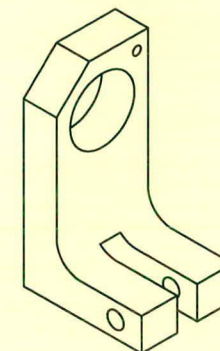
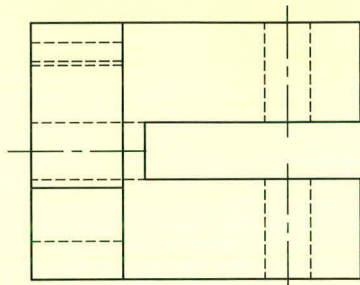


(-5)
SLEEVE

DART AEROSPACE	
TITLE INSPECTION FIXTURE FAN ASSY. TRANS & COUPLING	
DWG NO. RBH5610-705-40101-5	REV 3
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT SEE -A WELDMENT	.XXX ± .005 FRACTIONS ± 1/8
FINISH SEE -A WELDMENT	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125° ✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	MD500
SCALE 1:1	DATE 6/11/2012
SHEET 7 OF 15	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3	16-0067	-6 CH'D DIM WAS 2X .50 IS 2X (.50), ADDED LEADER TO 2ND FACE TO SKIM CUT, CH'D DIM WAS Ø1.0012 - 1.0000 IS Ø.9828 - .9816 S.F. -5.	7/5/2016	RJC	JAG



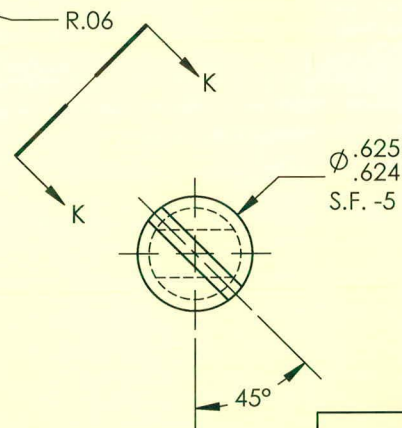
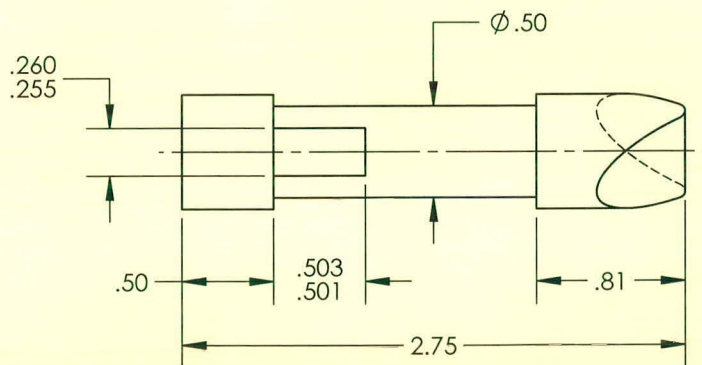
DART AEROSPACE	
TITLE INSPECTION FIXTURE FAN ASSY. TRANS & COUPLING	
DWG NO. RBH5610-705-40101-6	REV 3
MAT'L HR ANGLE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT SEE -A WELDMENT	.XXX ± .005 FRACTIONS ± 1/8
FINISH SEE -A WELDMENT	.XX ± .01 ANGLES ± .5°
SPEC	.X ± .1 SURFACES = 125
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	MD500
SCALE 1:1	DATE 6/11/2012
SHEET 8 OF 15	

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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
3	16-0067	-7 ADDED S.F. TO DIM Ø.625 - .624.		7/5/2016	RJC	JAG



AUX VIEW K-K

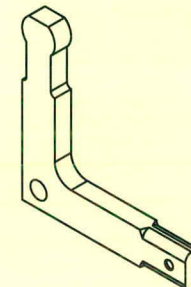
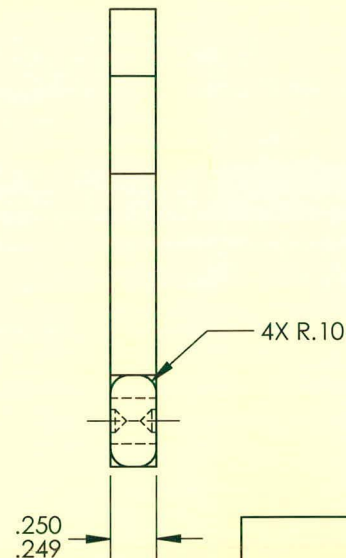


(-7)

PIN

DART AEROSPACE	
TITLE INSPECTION FIXTURE FAN ASSY. TRANS & COUPLING	
DWG NO. RBH5610-705-40101-7	REV 3
MAT'L 01	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 55-60	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX ± .005 FRACTIONS ± 1/8
SPEC QMSI-6.2.2 REV D	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125 ✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:1	DATE 6/11/2012
	USED ON MODEL MD500
	SHEET 9 OF 15

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0289	-8 CH'D DIM WAS .600 IS .65.	9/3/2015	RJC	JAG

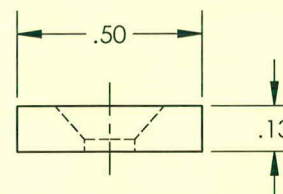
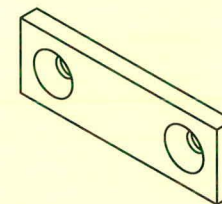
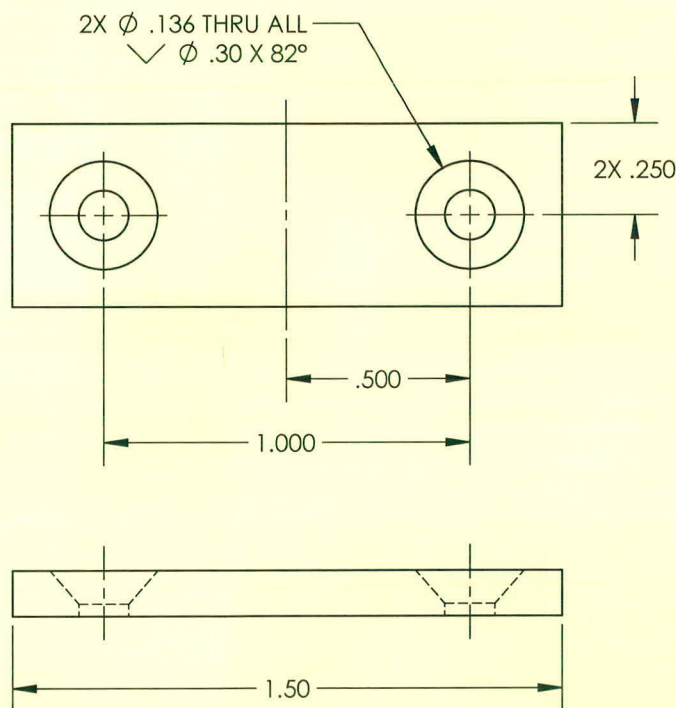


⑧
EVER

			
TITLE TRANSDUCER FIXTURE FAN ASSY. TRANS & COUPLING			
DWG NO. RBH5610-705-40101-8			REV 3
MAT'L 01		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT TREAT RC 56-60		.XXX $\pm$.005 FRACTIONS $\pm$ 1/8	
FINISH BLACK OXIDE		.XX $\pm$.01 ANGLES $\pm$ 5°	
SPEC QMSI 6.2.2 REV D		.X $\pm$.1 SURFACES = 125 $\sqrt$	
DRAWN BY: CLOUGH		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED: DUERFELDT		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPTS APPR: ANDERSON		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR: LINDSAY		USED ON MODEL	
APPROVED: GILBERT		MD500	
SCALE 1:1	DATE 6/11/2012	SHEET 10 OF 15	

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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
2	15-0289	-17 CH'D DIM WAS 2X ϕ .136 THRU ALL $\checkmark$ ϕ .252 X 82° IS 2X ϕ .136 THRU ALL $\checkmark$ ϕ .30 X 82°.			9/3/2015	JAG



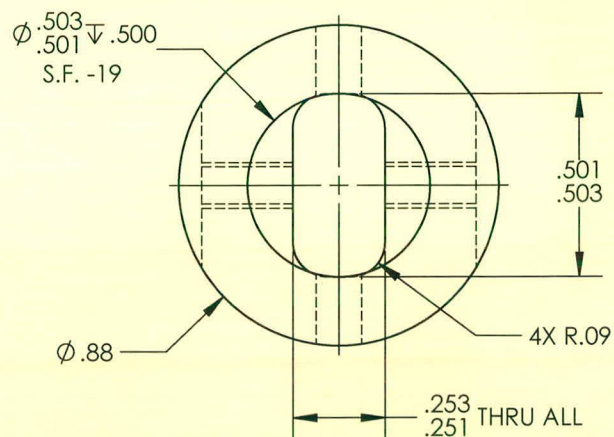
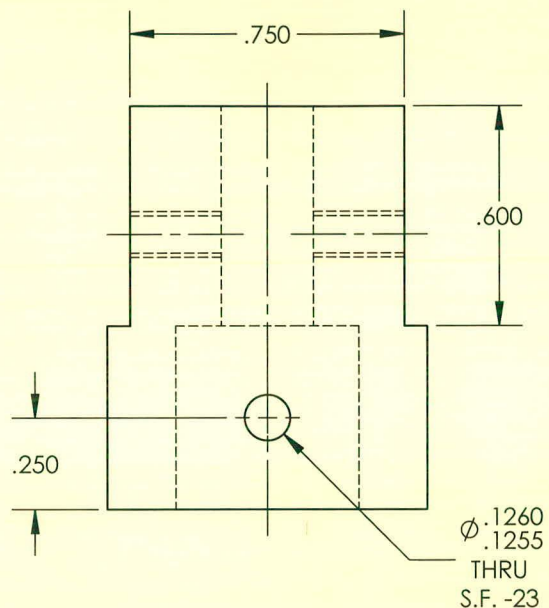
(-17)

SMALL PLATE

DART AEROSPACE	
TITLE INSPECTION FIXTURE FAN ASSY. TRANS & COUPLING	
DWG NO. RBH5610-705-40101-17	REV 3
MAT'L 01	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT RC 56-60	.XXX $\pm$.005 FRACTIONS $\pm$ 1/8
FINISH BLACK OXIDE	.XX $\pm$.01 ANGLES $\pm$ 5°
SPEC QMSI-6.2.2 REV D	.X $\pm$.1 SURFACES = 125° $\checkmark$
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	MD500
SCALE 2:1	DATE 6/11/2012
SHEET 11 OF 15	

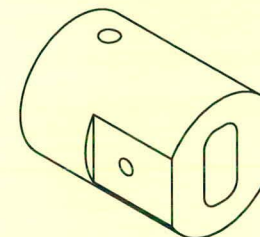
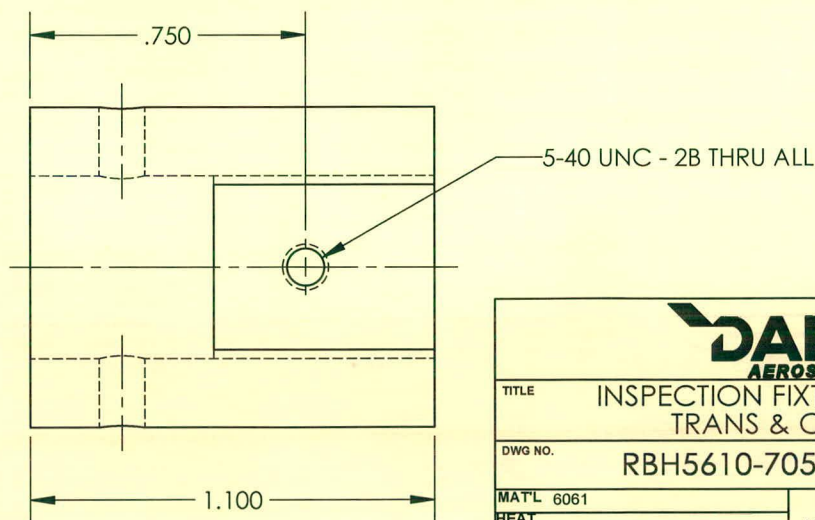
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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3	16-0067	-18 CH'D DIM'S WAS Ø.503-.501 THRU IS Ø.503-.501 ∇ .500, WAS .253-.251 ∇ .60 IS .253-.251 THRU ALL, ADDED S.F. -19 TO Ø.503-.501 ∇ .500 DIM.	7/5/2016	RJC	JAG



(-18)

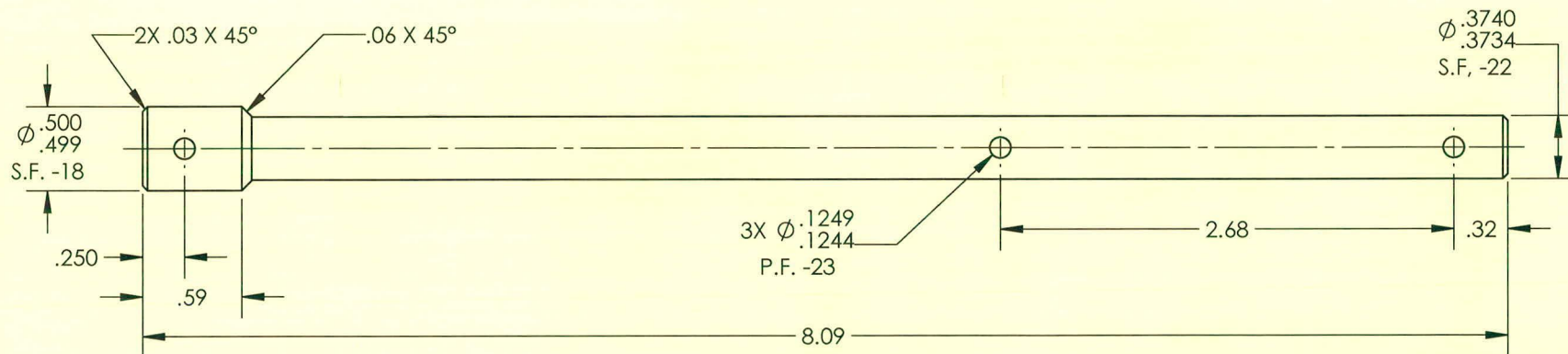
SMALL SLEEVE



DART AEROSPACE	
TITLE INSPECTION FIXTURE FAN ASSY. TRANS & COUPLING	
DWG NO. RBH5610-705-40101-18	REV 3
MAT'L 6061 HEAT TREAT FINISH ANODIZE BLACK SPEC MIL-A-8625F, TYPE II, CLASS II	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX $\pm$.005 FRACTIONS $\pm$ 1/8 .XX $\pm$.01 ANGLES $\pm$ 5° .X $\pm$.1 SURFACES = 125 $\sqrt$	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: CLOUGH	USED ON MODEL
CHECKED: DUERFELDT	MD500
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 2:1	DATE 6/11/2012
SHEET 12 OF 15	

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REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	
2	15-0289	-19 CH'D DIM WAS 2X Ø.1249 - .1244 IS 3X Ø.1249 - .1244 P.F. -23, DELETED DIM 7.12, CH'D DIM WAS (2.68) IS 2.68, WAS .65 IS .59, ADDED DIMS 2X .03 X 45°, .06 X 45°, .32	9/3/2015	RJC	JAG	
3	16-0067	-19 ADDED S.F. -18 TO Ø.500 - .499 DIM, ADDED S.F. -22 TO Ø.3740 - .3734 DIM, ADDED P.F. TO 3X Ø.1249 - .1244 DIM.	7/5/2016	RJC	JAG	

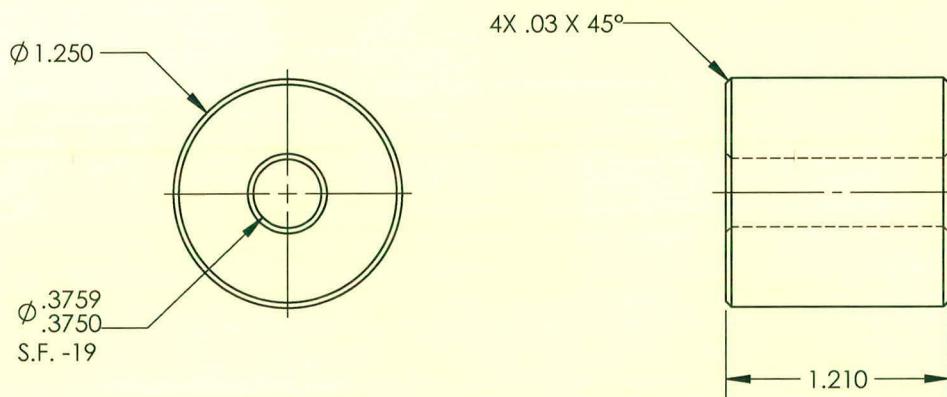
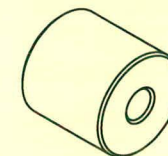


(-19)
LONG PIN

DART AEROSPACE	
TITLE INSPECTION FIXTURE FAN ASSY. TRANS & COUPLING	
DWG NO. RBH5610-705-40101-19	REV 3
MAT'L 6061	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH ANODIZE BLACK	.XX ± .01 ANGLES ± 5°
SPEC MIL-A-8625F, TYPE II, CLASS II	.X ± .1 SURFACES = 125/✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 X 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	MD500
SCALE 1:1	DATE 6/11/2012
SHEET 13 OF 15	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0289	-22 CH'D MATERIAL WAS 1018 IS 1018/1020.	9/3/2015	RJC	JAG
3	16-0067	-22 CH'D MATERIAL WAS 1018/1020 IS A36/1018/1020, ADDED S.F. -19 TO Ø.3759 ~.3750 DIM.	7/5/2016	RJC	JAG



(-22)
WEIGHT

DART AEROSPACE	
TITLE INSPECTION FIXTURE FAN ASSY. TRANS & COUPLING	
DWG NO. RBH5610-705-40101-22	REV 3
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH BLACK OXIDE	.XX ± .01 ANGLES ± 5°
SPEC QMSI-6.2.2 REV D	.X ± .1 SURFACES = 125 ✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	MD500
SCALE 1:1	DATE 6/11/2012 SHEET 14 OF 15

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REVISIONS			DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION			

RBH5610-705-40101

TOOL FUNCTION

TO CHECK FAN BELT DEFLECTION AT .17 TO .20 AND LOAD AS FOLLOWS:

<u>FAN PART No.</u>	<u>LOAD</u>
369H5610-705	1.00 – 1.75 LBS.
369D25610	1.75 – 2.00 LBS.

OPERATING INSTRUCTIONS

1. REMOVE WEIGHTED ARM FROM TOOL (FOR 369H5610-705 ONLY).
2. INSTALL TOOL TO REST AGAINST BELT AT SMALL PULLEY & LARGE PULLEY.
3. INSTALL WEIGHTED ARM ON TOOL (FOR 369H5610-705 ONLY).

NOTE: CHECKING THE TENSION OF THE 369D25610 FAN ASSEMBLY
DOES NOT REQUIRE THE WEIGHTED ARM TO BE REMOVED.

4. POSITION WEIGHT BETWEEN PIN STOPS AS REQUIRED TO PLACE FLUSH
PIN BETWEEN STEPS. FOR TENSION TO BE ACCEPTABLE, FLUSH PIN
MUST FALL BETWEEN STEPS.

NOTE:
INSTRUCTION CARD ON 4 X 4 RED PAPER.

DART AEROSPACE	
TITLE INSPECTION FIXTURE FAN ASSY. TRANS & COUPLING	
DWG NO. RBH5610-705-40101-27	REV 3
MATERIAL RED CONSTRUCTION PAPER	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT TREAT FINISH	.XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DUERFELDT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	MD500
APPROVED: GILBERT	
SCALE 1:1	DATE 6/18/2012 SHEET 15 OF 15

(-28)

INSTRUCTION SHEET



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040950**

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO040950

PO Date: 9/6/18

Due Date: 11/5/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	182938	RBH5610-705-40101P			Inspection Fixture Fan Assembly Trans & Coupling	Firmed	-	11/5/18	1 Ea	0 Ea	1 Ea	\$1,750.00/Ea	\$1,750.00

Grand Total: \$1,750.00

Order Notes

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/6/18 2:42 PM dart.Lussier.Patrick

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Att. Patrick Lussier

Shipment No: 24244
Shipment Date: 13-Nov-2018
Ship Via: Pick up at METEC
Order Number: 3020
Order Date: 09/06/18

Customer Code: DART
Phone: (613) 632-9577
PO Number: PO040950
Terms: 2% 10 - Net 30 Days

----- Quantity -----								
<u>Item</u>	<u>Open</u>	<u>Shipped</u>	<u>B/O</u>	<u>Canceled</u>	<u>Unit</u>	<u>Description</u>	<u>Revision</u>	<u>Job Number</u>
1	1	1 ✓	0	0	EA	DART-RBH5610-705-40101P Inspection Fixture Fan Assembly Trans. & Coupling - suggested price	3	3020-01

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Received In Good Order By
Att. Patrick Lussier



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev.#	P.O. Number
1 ✓	DART-RBH5610-705- 40101P ✓	Inspection Fixture Fan Assembly Trans. & Coupling	3	40950 ✓

DAS
68
9-89

MATERIAL: supplied by METEC

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


George Theoret

Vankleek Hill, November 13, 2018

CONFIDENTIAL

CONFIDENTIAL

Y